Work Order ID 11 February-24-14 10:04:49 A		*113	839*			/	1	Page 1
Item ID: D3537-1 Revision ID: Item Name: Wearpad		Accept	*N900040	100)* s	etup Star Stop	I U.	S1*
Start Date: 2/24/14 Required Date: 2/24/14 Reference:	Start Qty: 50.00 *50 Req'd Qty: 50.00 *50	* 24	Cust Item ID: Customer:					
Approvals: Process Pl	lan: MC5 Date: 14-02-	Z Tooling: SPC (Y/N):	Date:		R	tun Star Stop	"IVI	R1*
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Control of the Contro	evision Nbr							
100 Waterjet	FLOW WATER JET Memo	0.00		54	45	A	14-3-	-/3
FLOW CNC Waterjet	1-Cut as per Dwg D3537Dwg Rev: if necessary	Prog Rev: C	2-Deburr		A.			
*110 *110*	QC2- Inspect parts off machine FAI/FAIB Memo	0.00		34	3	- 2	14-3	-/3
Quality Control	Memo	,,,,,,						
120 *120*	QC8- Inspect parts - second check	DAS 0.00 16 9-89	•	(0	Ai			
QC Quality Control	Memo	0.00 17/0	3/13	(3	-	F	

DQA:		Date:									No. 1				
是/一支持/III	3-0				WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NOR		JINI OI		ork Order up	date only	AEROSPACE				
300		Dute		100	Maria de la compania del compania del compania de la compania del compania de la compania del compania de la compania del compania dela				rork order up	date only	1 34				
Work Order:					DISPOSITION			AGAINST D	EPARTMENT,	PROCESS					
ork order.				-	Rework	1		Skid-tube Crosstube	1	Water Jet	1 Factoristic				
Part No.					Scrap		i i	Machining Small Fab	Dro		Engineering				
, di Cito	1000				Use-as-is			noforming Finishing	_	d. Eng. Coor.	Quality				
NCR No.					Suspected Unapproved		men	Large Fab Composite	- Rec/Stor	e/Packaging	Other				
					Suspected Onapproved			composite_	_	Supplier					
Root				Desc	ription of work order update		nitial	Action	Sign &		A Property of the Control of the Con				
Cause	Date	Step	Qty	Desci	or non-conformance		ief Eng	Description	Date	Verification	QC Inspector				
Design	Dute	эсер	Qty	1-1	or non-comormance	Cit	ici Liig	Description	Date	vernication	QCTIISPECTOI				
Doc/Data					Programme and the second			E a							
Equip/Tooling								A part of the			10.00				
Hardling/Pre															
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Offset/Setup		3 989						2			2				
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Supplier	3.50														
Training				ine is							, ži				
Transport		1	PHI.												
Unapproved				61 A							350				
						FAL	JLT CAT	TEGORY			Ser Service				
Landing	Gear	1136			General		. 17	- A Section			- FMC + GE				
	Bending				Bend		Folio/P	Program	Outside Dim	ensions	Pressure/Forced				
	Centre No	ot Concer	ntric		BOM/Route		Grain	400	Over/Under	tolerance	Set-up				
TO THE	Cracks				Broken/Damage/Defect		Hardwa	ire	Part Incorrec	i	Temperature/Cure				
100	Crimp/Kir	nk/Ripple	/Wave	BELLE .	Burrs		Inspect	ion Incomplete/Unqualified	Part Lost/Mi	ssing	Weld				
4=74	Cuffs				Contamination	-	Instruct	tions Incomplete/Unclear	Part Moved		Wrong Stock Pulled				
THE REAL PROPERTY.	Crushing				Countersink		Misalig	gned/off center	Positioned V	The second secon	36				
AFF THE	Heat Trea	it			Cut Too Short	EY/O	Mislabe	eled	Power Loss/	Surge	Other				
- 3	Inspection		Tube		Drawing		Misread	d	2	No like I					
	Marks/Ch				Drill Holes		Off-set				11.00				
0	Turning S				Finish		A CONTRACTOR AND A CONTRACTOR	Calibration							
fac 130	Wave/Tw	ist in Tub	e	- 1	Fit/Function		Out of	Sequence							

Work Order February-24-14 10			*113	3839*						Page 2
Revision ID:	3537-1 earpad		Accept	*N900	040	100)* s	etup Start Stop	*N:	S1* S2*
Start Date: 2/2 Required Date: 2/2 Reference:	24/14 Start Qty: 50. Req'd Qty: 50.			Cust Item I Customer:	D:					
	rocess Plan:	Date:	Tooling: SPC (Y/N):		ate:		R	Stop	^IVI	R1*
Sequence ID/ Work Center ID 130 *130* Brake NC		as per Dwg D3537 on CNC br. as D3537-1	Set Up/ Run Hours 0.00 0.00 ake using Jigs DT 8261 a	Tool ID and DT 8326.2-	Tool # DAS 30 9-89	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp 14(63/13
*140 *140* Large Fab	Large Fab Memo Memo Weid the	Description Batc 1-Weld as per Dwg D353 t penetrated through Wearpadi	using Jig DT 82102-R	dcoat emove any			24			14-03
*150 *150* QC Quality Control	QC10- Inspect visua	l per QSI004- ground welds	0.00				2	14-03	5-14	DAS 9 9-89

DQA:			Date:												
**	1				B.	WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE			DARI			
QA Closed:			Date:							Vork Order up	odate only	7			
Work Orde	er:					DISPOSITION			AGAINST D	EPARTMENT	/PROCESS				
Part N	lo.					Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab moforming Finishing	700 00000	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other			
NCR N	lo			Ř		Suspected Unapproved			Large Fab Composite	Supplier					
Root		100	9,1	1000	Desci	ription of work order update	- 1	nitial	Action	Sign &		77 . XII			
Cause		Date	Step	Qty	K	or non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process															
Supplier Training Transport Unapproved					ier M s		TO THE ALL								
100							FAI	JLT CA	TEGORY			3 143			
Landi	-	iear Bending				General Bend		Folio/F	Program	Outside Dim	ensions	Pressure/Forced			
		Centre No	ot Concer	ntric		BOM/Route		Grain		Over/Under	_	Set-up			
1 A		Cracks			EN B	Broken/Damage/Defect		Ha dwa	are -	Part Incorre		Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave	86	Burrs	100		ion Incomplete/Unqualified	Part Lost/Mi	ssing	Weld			
9. 类.	=	Cuffs	200			Contamination		And the second	tions Incomplete/Unclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Diff College Comme	gned/off center	Positioned V	and the same of th				
		Heat Trea	it			Cut Too Short		Mislabe		Power Loss/		Other			
		Inspection	ion Strip in Tube Drawing					Misrea	_	5.88					
Maria a pr	Marks/Chatter					Drill Holes		Off-set	を						
		Turning S				Finish	Service	1	Calibration			W. All			
69	Wave/Twist in Tube					Fit/Function	Out of Sequence								

Work Order February-24-14 10			*113	839*			Page 3
Revision ID: Item Name: We	24/14 Start Qty: 50 Req'd Qty: 50			*N900040 Cust Item ID: Customer:	1100*	Setup Star Stop	14.21
Approvals: Pr	rocess Plan:	Date:	Tooling:	Date:	1	Run Star	"IMHI"
Q	C:	Date:	SPC (Y/N):	Date:		Stop	*NR2*
Sequence ID/ Work Center ID 160 *160* QC Quality Control	Operation Description QC5- Inspect part	completeness to step on W/O	Set Up/ Run Hours 0.00	Tool ID Tool #	Code Qty		Reject Insp. Number Stamp DAS 9 9-89
170 Powdercoat Powder Coating	M /25		0.00 0.00 OVEN TEMPERATURE:		2	4 \$ 1.	4-3.14
1 AO QC Quality Control	QC3- Inspect Part		0.00		_2	4 SA	0 14/03/14

DQA:		Date:		Carl								POADT
	1613		31-		WORK ORDER NON	DARI						
QA Closed:	V×10	Date:						15	Wor	k Order up	date only	7
Work Order:				(1) Y	DISPOSITION			AGAINST I	DEP	ARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root Cause	Date	Step	Qty	Desci	ription of work order update or non-conformance		nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
		القتا				FAL	JLT CAT	regory				138
Landing	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning Se	t Strip in atter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set Out of O	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d	P P P	Outside Dim Over/Under art Incorrec art Lost/Mi art Moved ositioned V ower Loss/S	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
15	Wave/Tw	ist in Tub	e		Fit/Function		Cut of 9	Sequence				572,3

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Č.														
Work Orde February-24-14				*113	3839*		Page 4							
Revision ID: Item Name:	D3537-1 Wearpad 2/24/14 2/24/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*	Accept	*N900 Cust Item Customer:	ID:	100)*	Setup	Stop	*N:	S1* S2*		
Approvals:	Process Pl QC:	an:	Date:	Tooling: SPC (Y/N):)ate:)ate:			Run	Start Stop	"171	R1*		
Sequence ID/ Work Center II 190 *1 QO* Packaging Packaging 200 *200 *200 QC Quality Control		Operation Description Identify as per dwg & Sto Memo QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Code	Accep Qty	Qty	_	Reject Number			

C ** 15.32

DQA:		Date:													
		. Dutc.			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON		JINITO	MINIANCE / OPDATE	Mark	Orderus	odate only	AEROSPACE			
		Dute.		and the same	REAL PROPERTY.				VVOIK	Order up	date only				
Work Order					DISPOSITION			AGAINST	DEPAI	RTMENT	/PROCESS				
			1000		Rework	1		Skid-tube Crosstube			Water Jet	Engineering			
Part No).				Scrap										
		4000	HITCH		Use-as-is			noforming Finishing			re/Packaging	Quality Other			
NCR No),				Suspected Unapproved	1		Large Fab Composite			Supplier				
a segui				24.3											
Root				Desci	ription of work order update	1	nitial	Action		Sign &		XXIII			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector			
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Equip/Tooling	1011	7 19	THE S												
Handling/Pre								F							
Material															
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Supplier															
Training			1 1 2					te i de la companya d							
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Unapproved		1111	11121					D)							
# 1200						FAI	ULT CAT	TEGORY				United Table			
Landing	Gear				General			The state of the s							
	Bending				Bend		Folio/P	Program	Ou	tside Dim	ensions	Pressure/Forced			
	Centre No	ot Concer	ntric	71 22	BOM/Route		Grain		Ov	er/Under	tolerance	Set-up			
	Cracks			2	Broken/Damage/Defect		Hardwa	re	Par	rt Incorrec	i	Temperature/Cure			
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	Par	rt Lost/Mi	ssing	Weld			
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear	Par	rt Moved		Wrong Stock Pulled			
	Crushing				Countersink		Misalig	ned/off center	Pos	sitioned V	Vrong				
Material Section	Heat Trea			3	Cut Too Short		Mislabe	eled	Por	wer Loss/	Surge	Other			
	Inspection		Tube		Drawing	1	Misread		_			(P4.2. M)			
	Marks/Ch				Drill Holes	()	Off-set								
	Turning S			9	Finish	-	-	Calibration	-			15216			
CI WILLIAM I	Wave/Tw	ist in Tub	90	HITE SA	Fit/Function		Outlof 9	Sequence							

Picklist Print

February-24-14 10:04:49 AM

Work Order ID: 113839

113839

Parent Item:

D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 2/24/14

Required Date: 2/24/14

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M364S16GA		Purchased	No			100	sf	217.1370	0.106	6			
M304S16	GA								**	D	14-7-1	3	

304/316 Sheet .063

Location Loc Code Loc Qty MAT020 217.137 M126915 1.487 M127821 129,33 M128054 86.32

DQA:		Date:													
					WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:								ork Order u	odate only	AEROSPACE			
1 1 1 1	HAN EL			-	DISPOSITION				AGAINST D	PARTMENT	/ppocess				
Work Order:	en , -	111			DISFOSITION	.			AGAINST DI	-	/FROCE33				
					Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part No.	-121				Scrap		(Machining	Small Fab	-	d. Eng. Coor.	Quality			
					Use-as-is							Other			
NCR No.			- 1		Suspected Unapproved			Large Fab	Composite		Supplier				
0				2											
Root	Data	Carr	04.	Desci	ription of work order update		nitial		ction	Sign &					
Cause	Date	Step	Qty		or non-conformance	Cn	ief Eng	Des	scription	Date	Verification	QC Inspector			
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Doc/Data Equip/Tooling			ij					==				in its			
Handling/Pre								5				4			
Material				1- 1											
Operator				1											
Offset/Setup		17.5	1												
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Supplier			- 1	Star - ITTE				of her				1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			
Training															
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Unapproved				Land I											
No.			1			FAL	ULT CAT	TEGORY				- 48.			
Landing	Gear				General		0.11	1,74		_					
	Bending				Bend		Folio/P	rogram	We set if	Outside Dim	ensions	Pressure/Forced			
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up			
	Cracks			218	Broken/Damage/Defect		Hardwa		2	Part Incorre	ci	Temperature/Cure			
	Crimp/Kink/Ripple/Wave Burrs				$\overline{}$	6.0	ion Incomplete/		Part Lost/Mi		Weld				
	Cuffs		1	Contamination		1	ions Incomplete		Part Moved		Wrong Stock Pulled				
	Crushing		Countersink	-	ALDERSON IN	ned/off center	r	Positioned V							
Nacy Co	Heat Treat Cut Too Short					Mislabe			Power Loss/	Surge	Other				
Inspection Strip in Tube Drawing				Misread											
100 100 100 100 100 100 100 100 100 100			Drill Holes	Off-set					1.32						
Turning Sequence Wave/Twist in Tube				100	Finish	Out of Calibration						ALL DATE OF THE PARTY OF THE PA			
Section Name of State	I wave/Iw	ist in Tub	96	FEW ROPT	Fit/Function	1	Out of	Sequence							

DART AEROSPACE LTD	Work Order: 113,839
Description: Wearpad	Part Number; D3537-1
Inspection Dwg: D3537 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.26	/		1 JEM 05	
3.500	+/-0.010	3. 563	/			
1.965	+/-0.010	1.974	1			,
2.795	+/-0.010	2.795	~			
3.625	+/-0.010	3.625	V			
0.220 x 0.380	+/-0.010	6.230× 0.38				

Measured by:	a	Audited by:	DAS 16	Prototype Approval:	N/A
Date:	14-3-13	Date:	9-89 14/63/17	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	Α	07.03.21	New Issue	KJ/JLM	
	В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
	C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM X	adl
100				i ()	7~./





